



- α - Rake angle
- ϕ - Shear plane angle
- γ - Clearance angle
- t_0 - Undeformed chip thickness
- t_c - Deformed chip thickness
- V_c - Cutting velocity

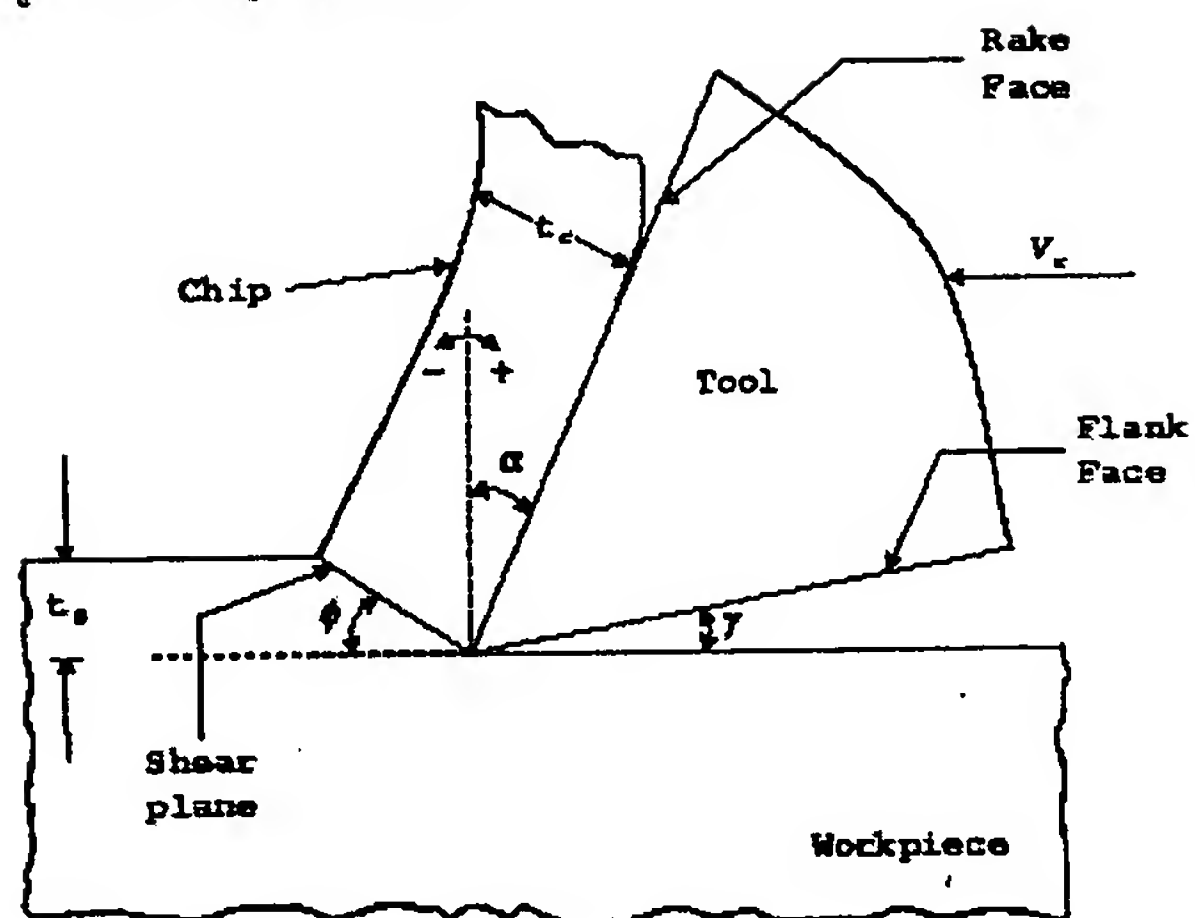


Figure 1

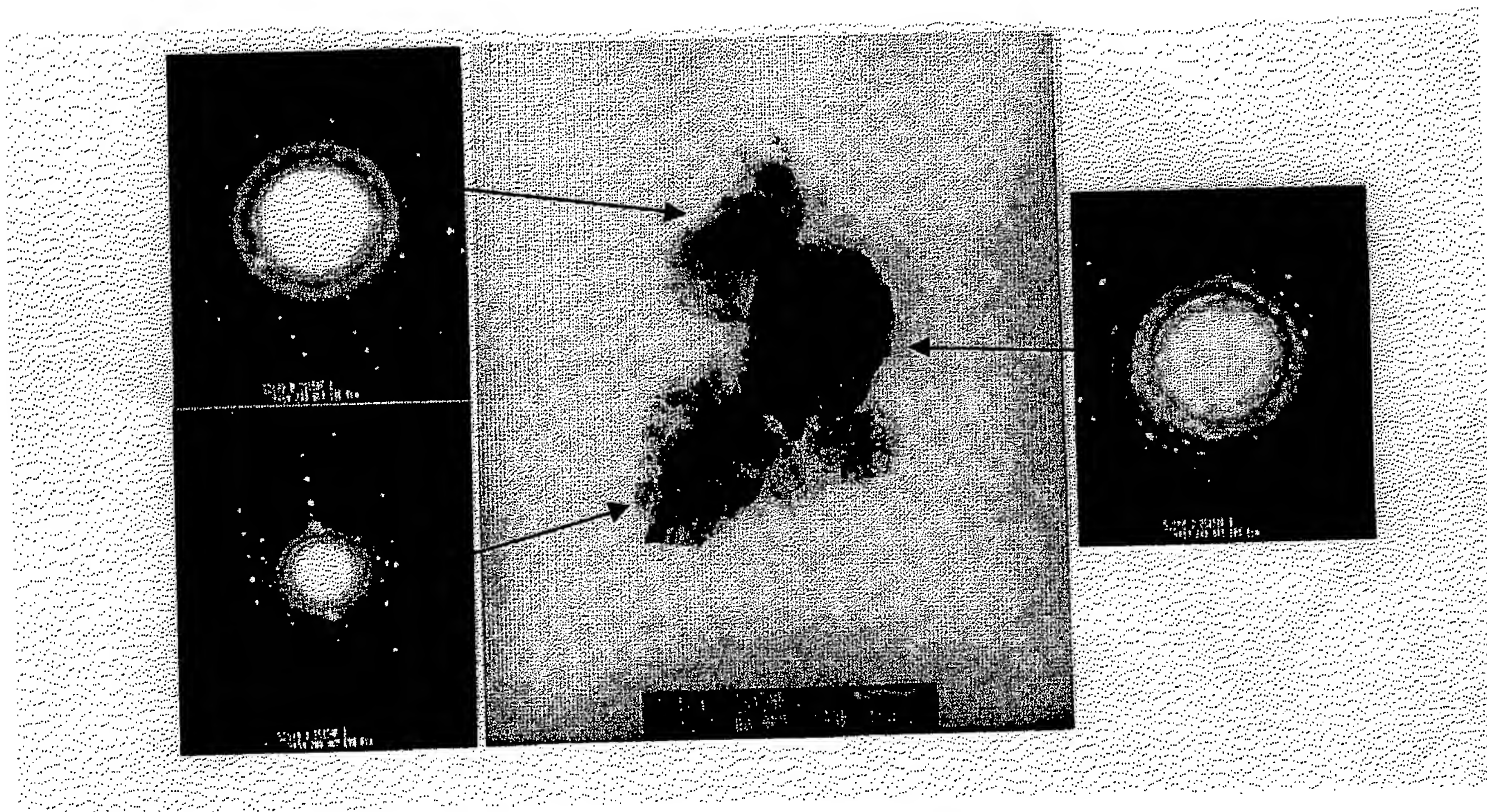


Figure 2

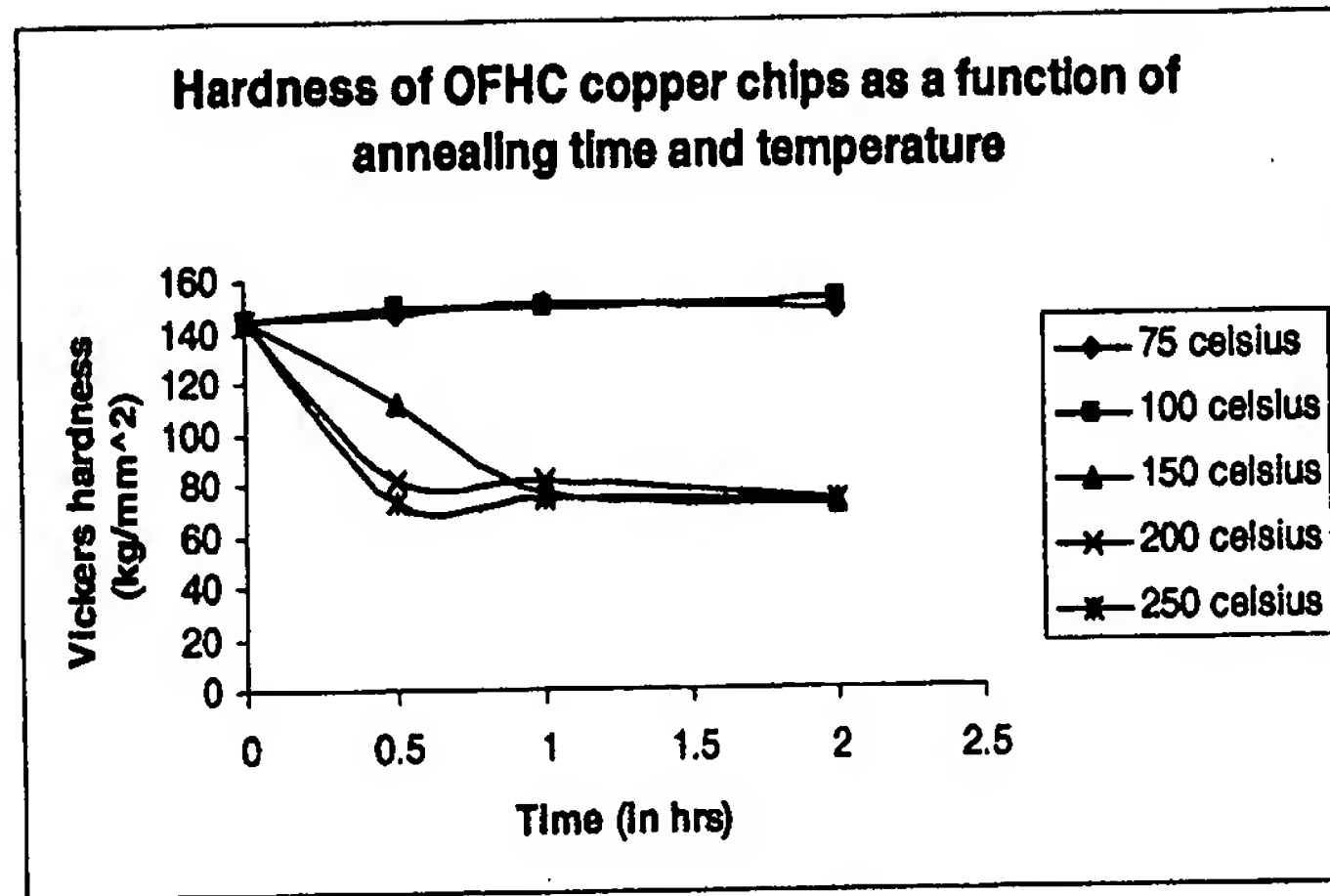
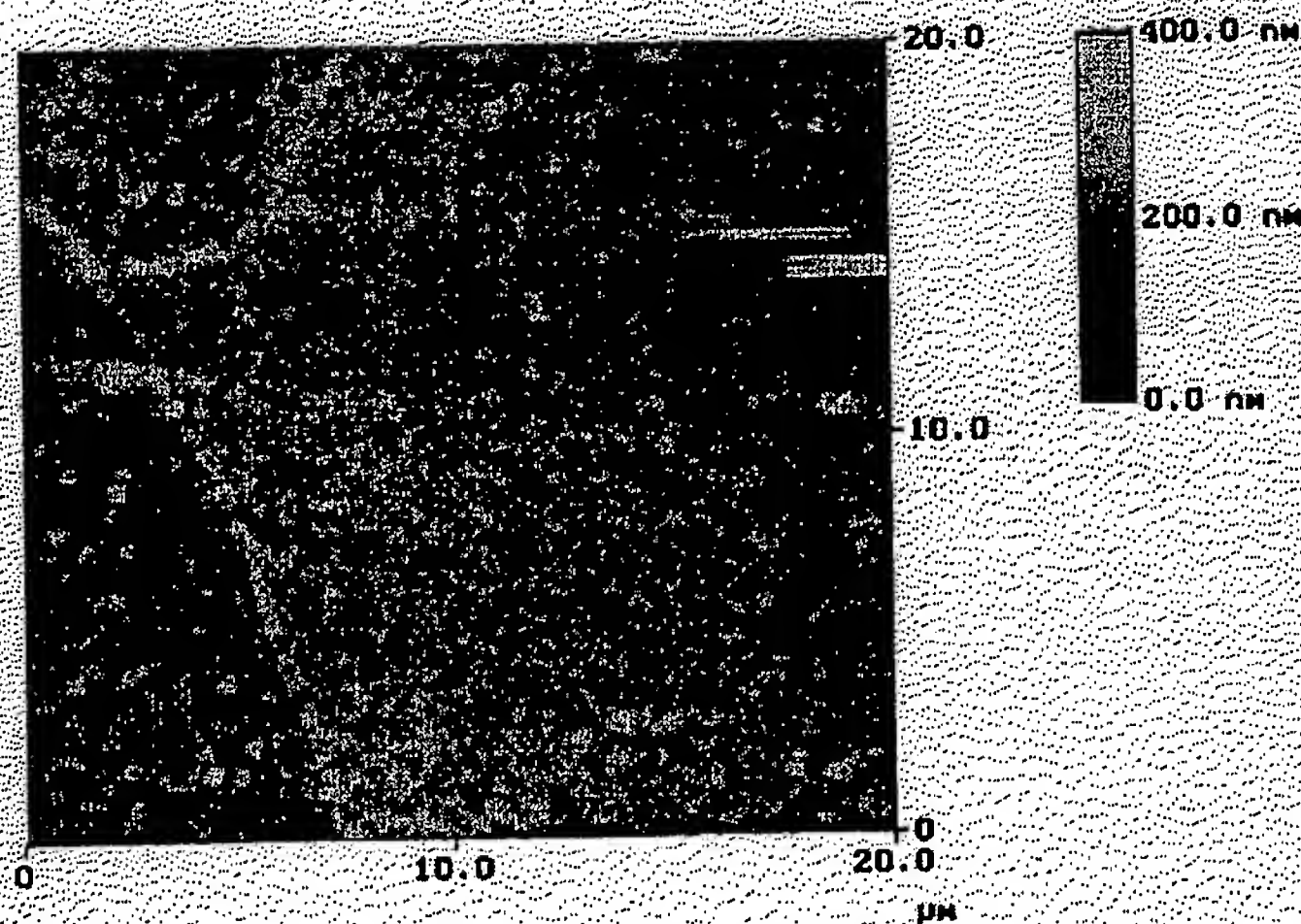
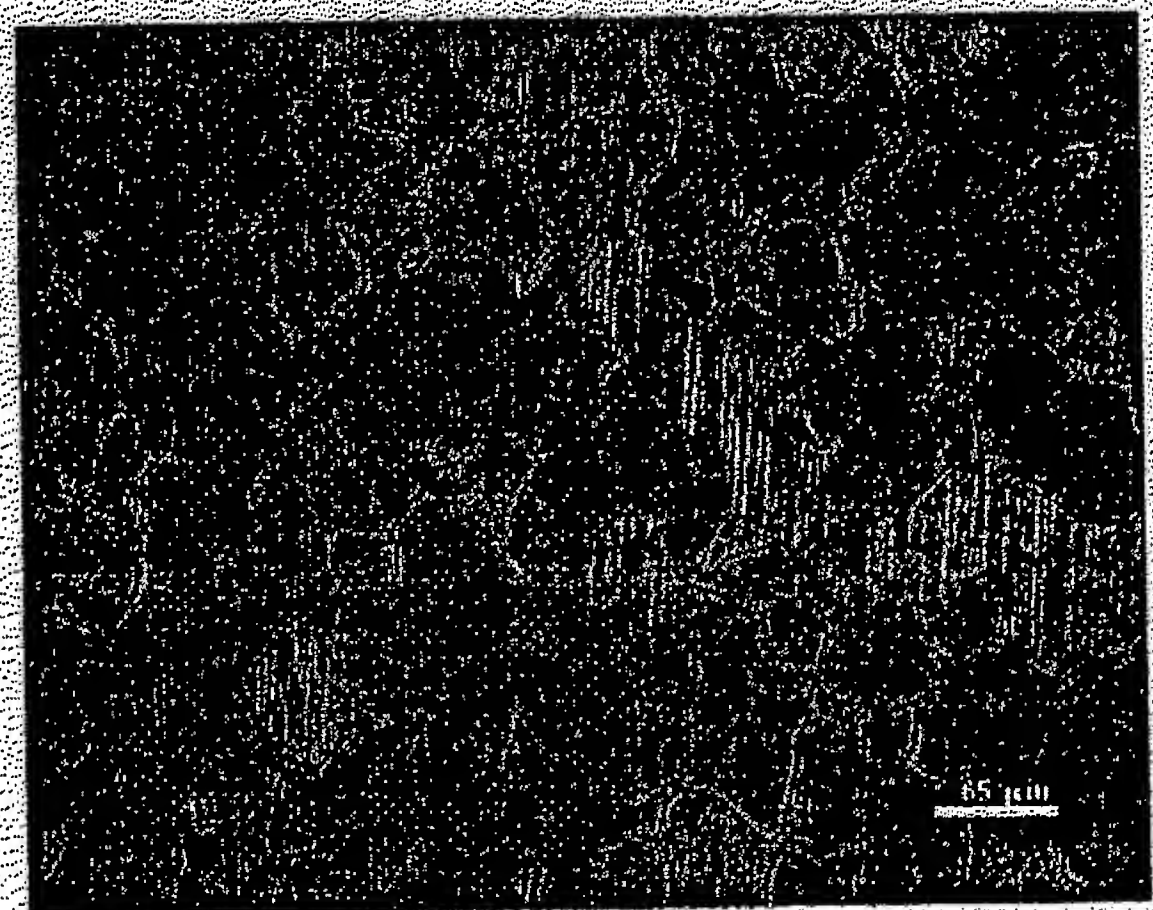


Figure 3

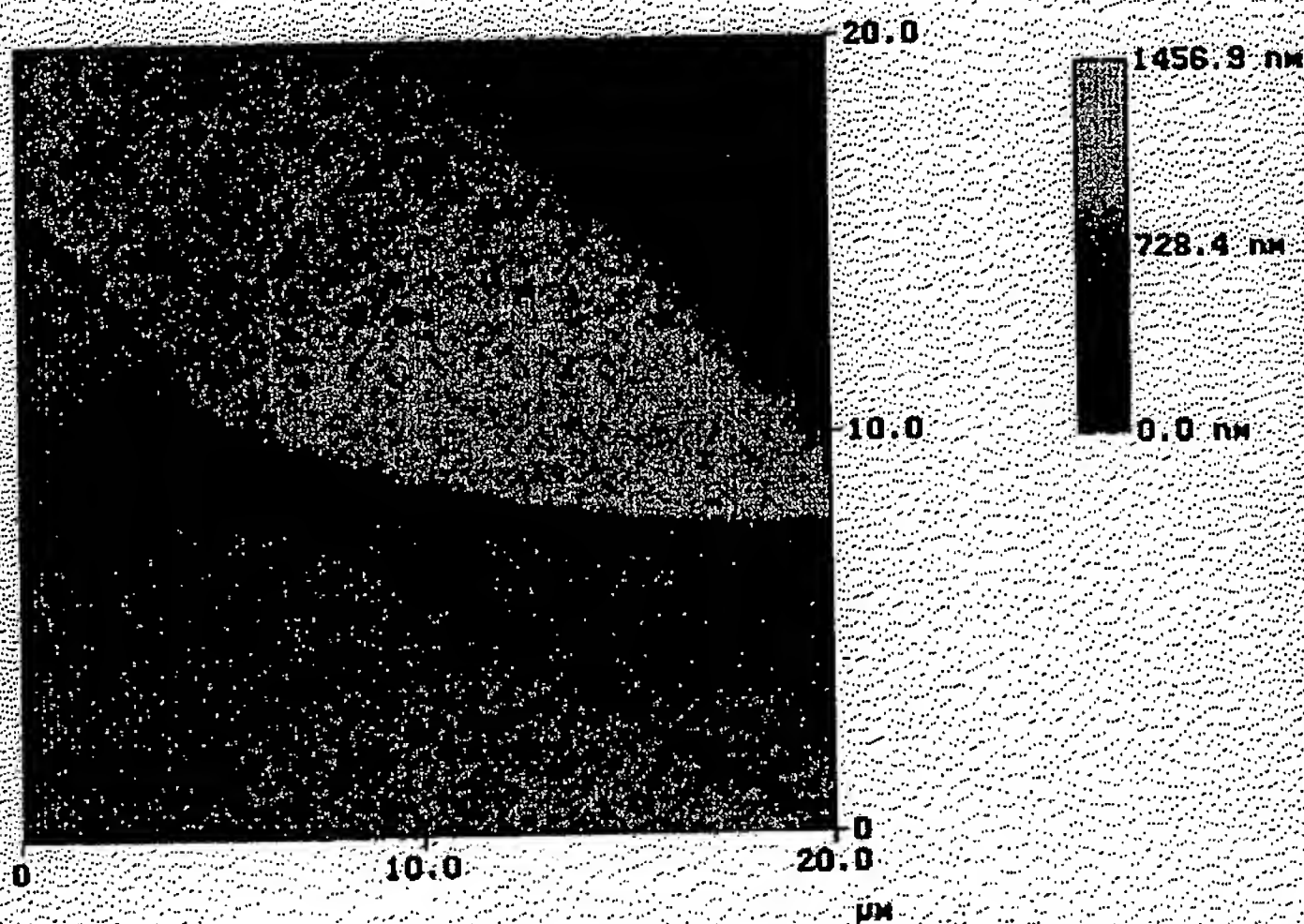


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Figure 4

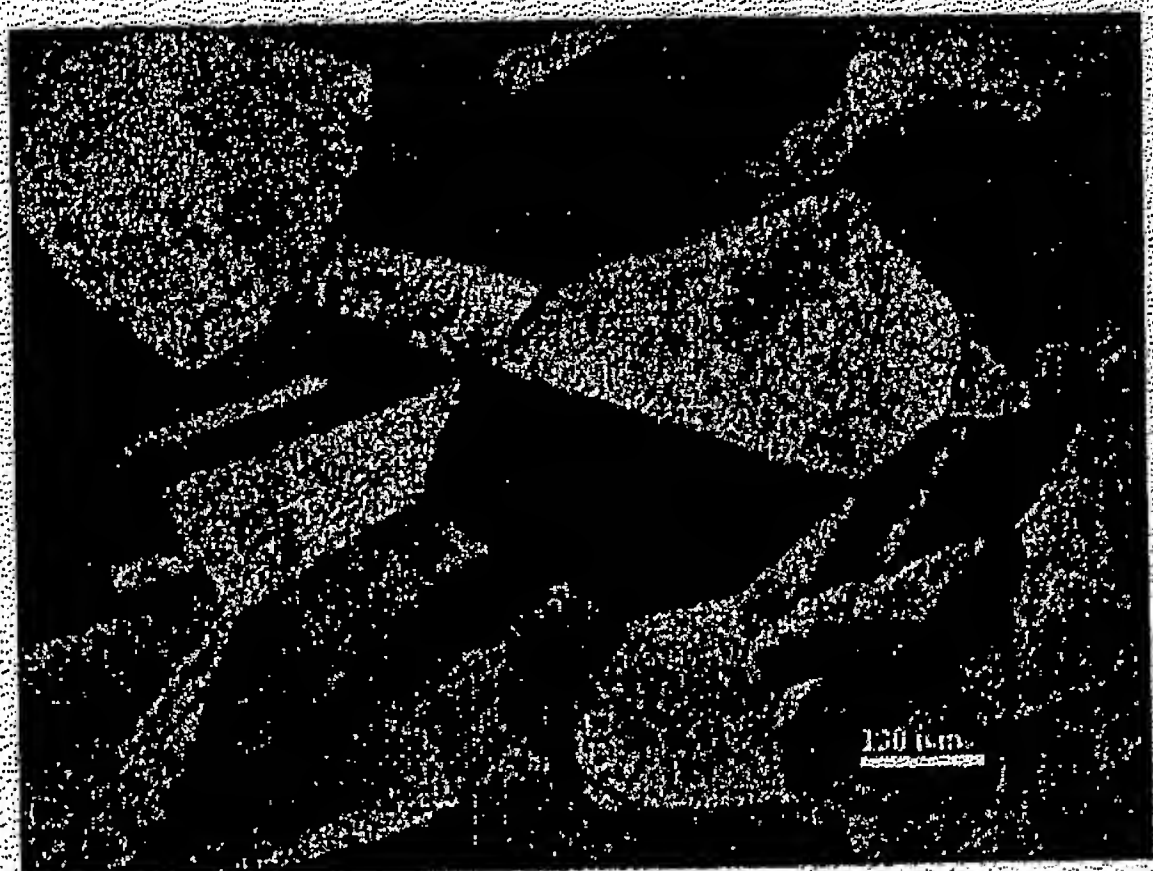


Optical Microscope

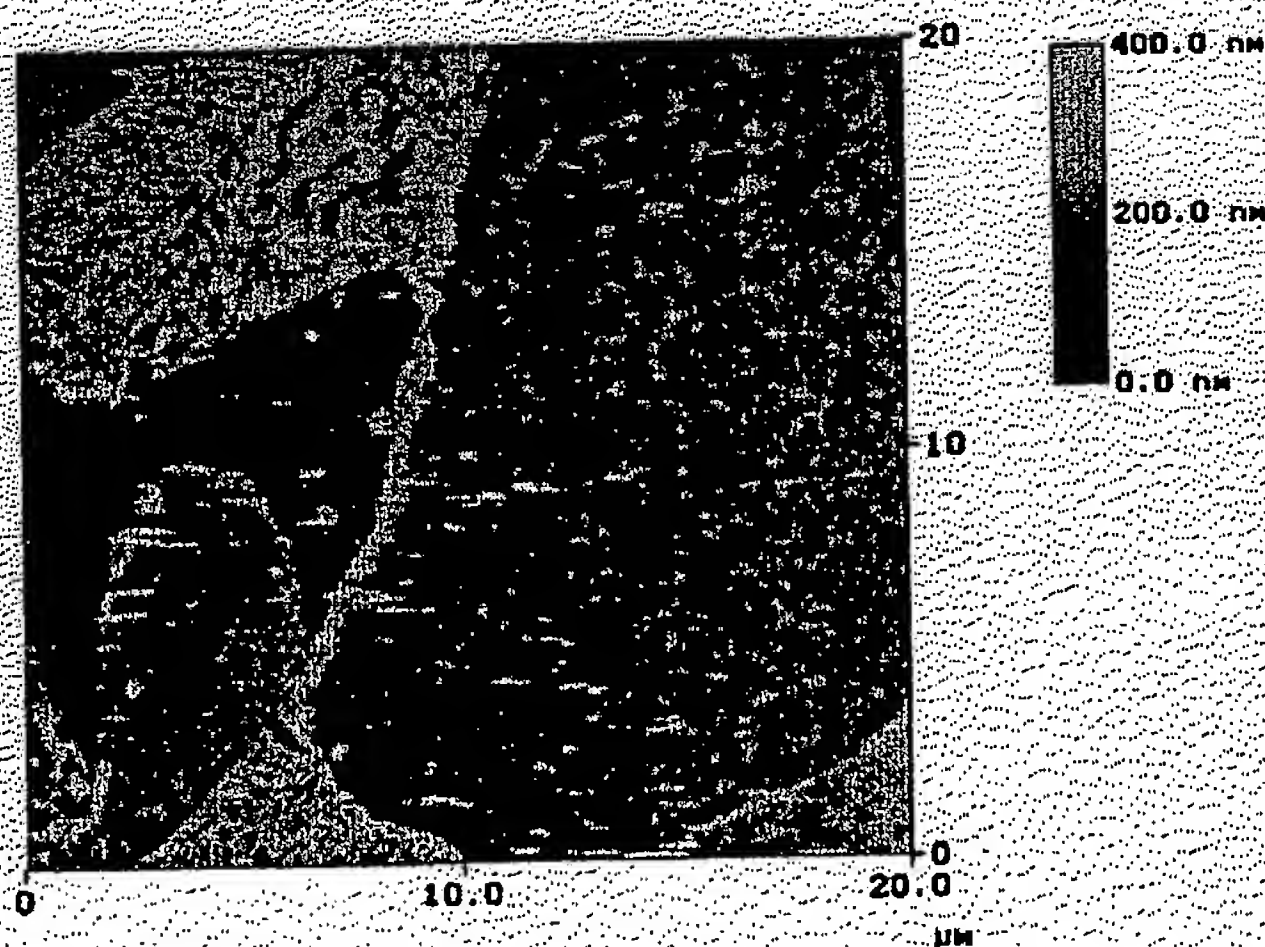


AFM

Figure 5

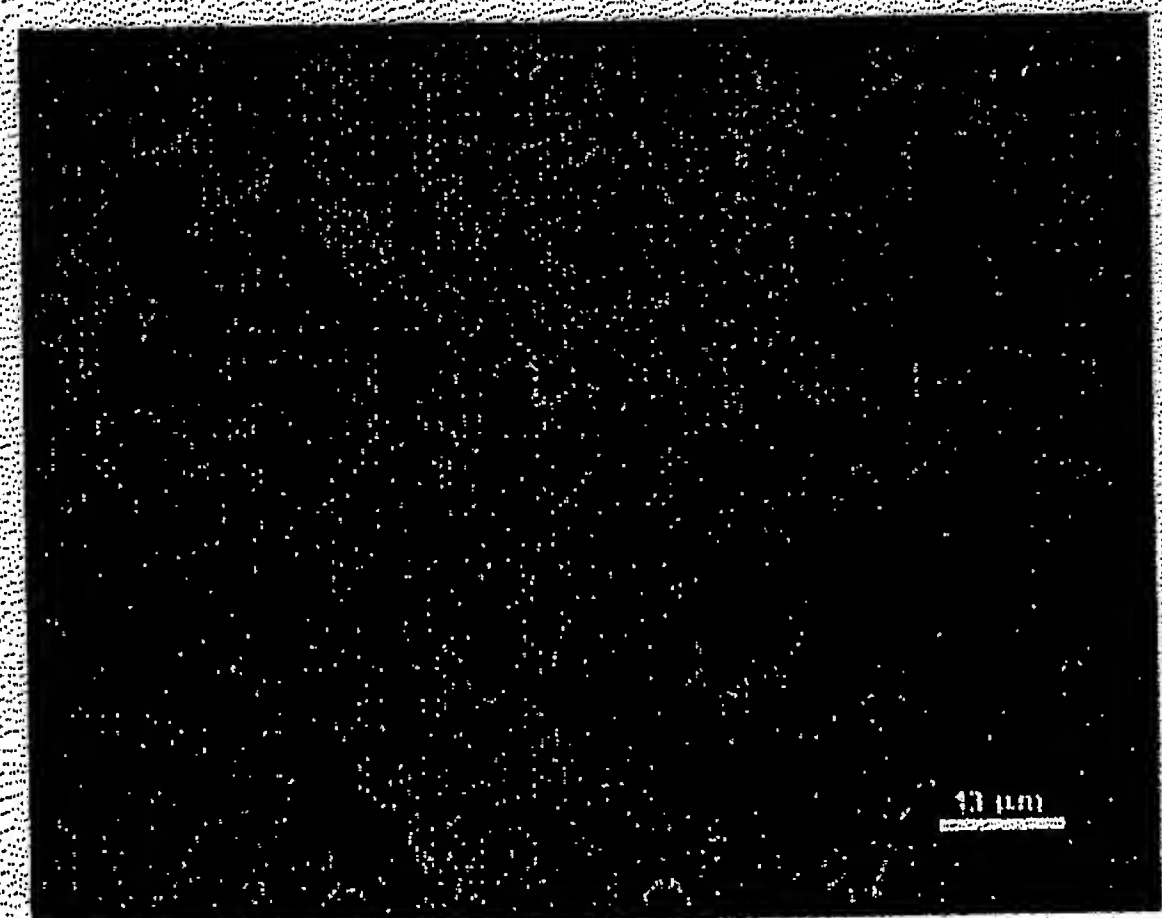


Optical Microscope

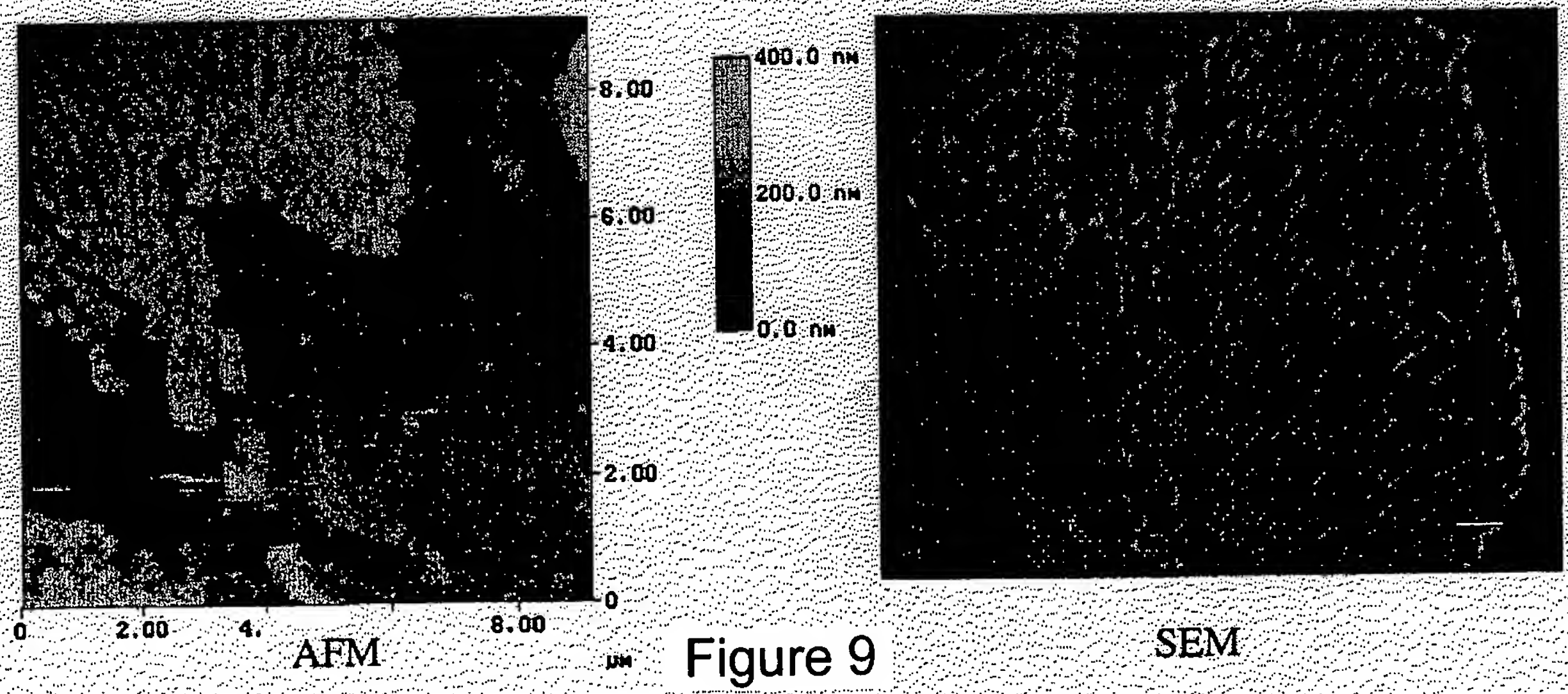
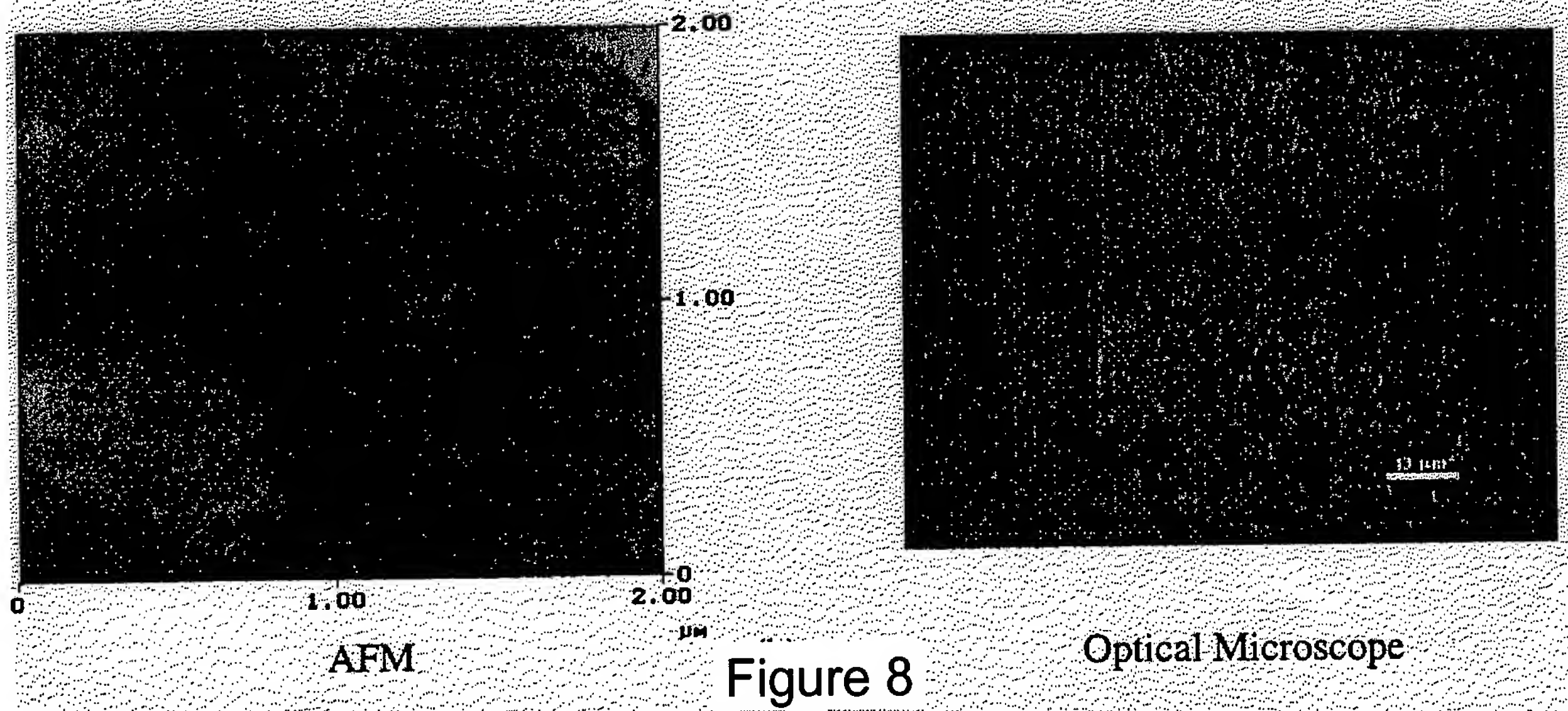
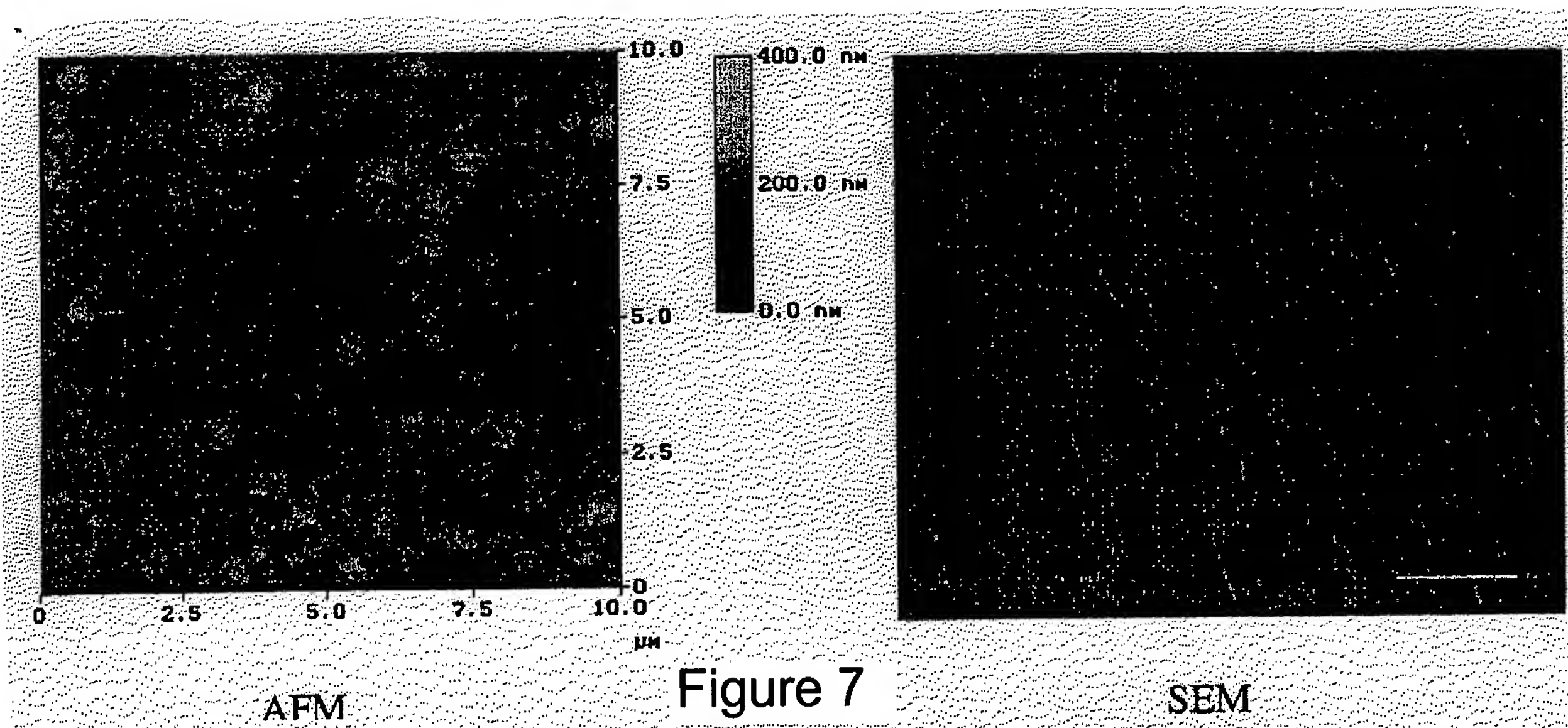


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Figure 6



Optical Microscope



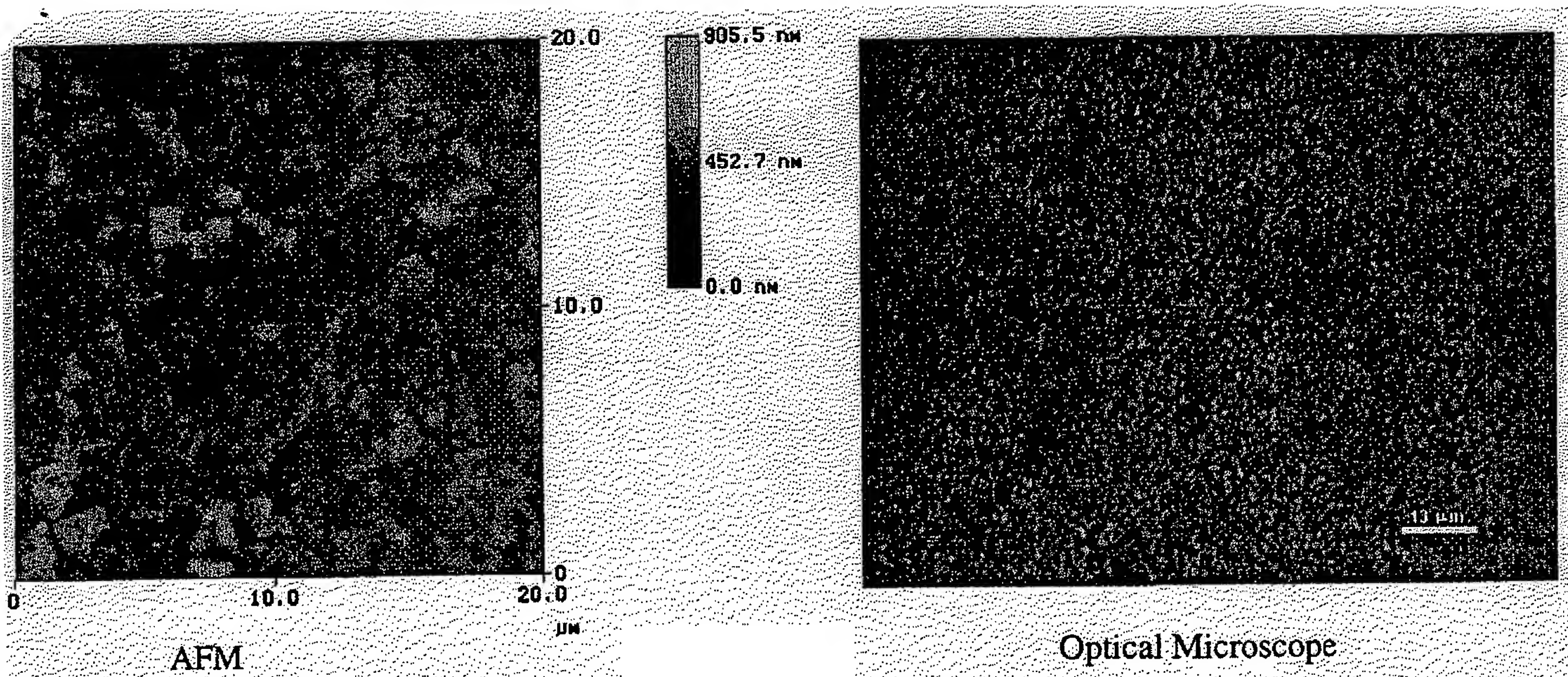


Figure 10

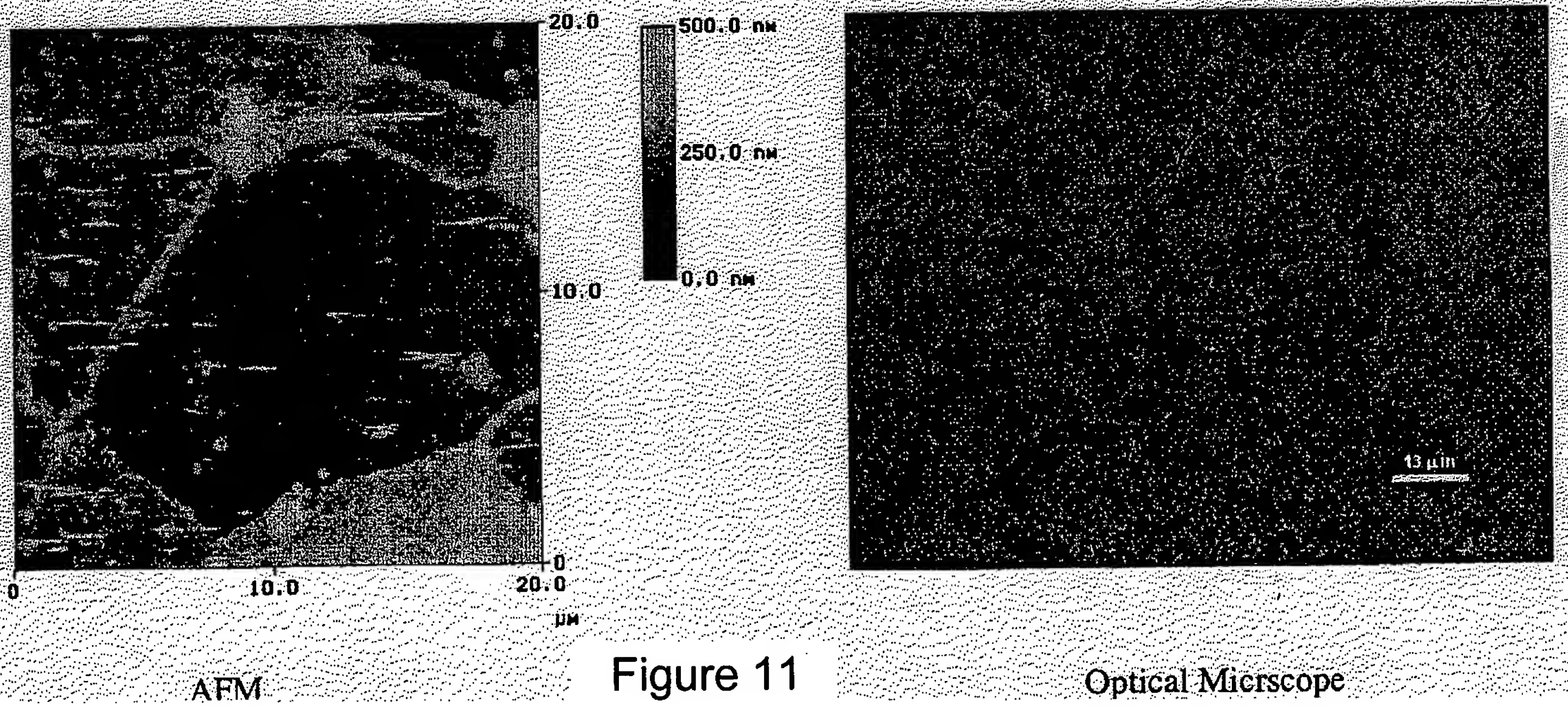


Figure 11